

Work Order ID 57967

April 21, 2010 9:20:08 AM



Page 1

Item ID: D4038-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle, Aft, LH

Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

[Handwritten signature]

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

B

100

0.00



Bandsaw

Memo

7.635 mt

0.00

Cut Blank *7.125"* long

mt = 10/04/21

4 0

Jeaspa Bandsaw

110

0.00



HAAS 1

Memo

Mill as per Dwg & Folio FA880

Dwg Rev: *B*

Folio Rev: *1.1*

0.00

mt = 10/04/21

4 0

HAAS CNC vertical machine #1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4038-3 PAR #: _____ Fault Category: Prod-Eng-Correl NCR: Yes No DQA: Yes No Date: 10/05/05
 Resolution: SCVAP Disposition: SCVAP QA: N/C Closed: Yes No Date: 10/05/04

NCR: <u>57967</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/05	110	Blank are cut too short ~ W/O step 100 is wrong Blank are 9.125 should be 7.125 Part is 7.500 long R.L. work order is wrong LOA.	<u>JB</u> <u>Q9902</u>	Use blank for next 4038-1 Job Replace <u>M113391</u> x 4	<u>mw</u> 10/04/05	<u>amb</u> 10/04/26	<u>JB</u> <u>Q9902</u>	<u>S</u> 10/04/26
			<u>JB</u> <u>Q9902</u>	→ Fix Detail in work order.	<u>amb</u> 10.04.26	<u>JB</u> <u>Q9902</u>	<u>S</u> 10/04/26	

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



mw 10/04/25

4 0

ark 10/04/26

4 10

H BK 10-4-27.

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Item ID: D4038-3

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Setup Start



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Start Date: 23/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

JH 10/04/27

X4 6

160

Identify as per dwg & Stock Location: 114

0.00



Packaging

Memo

0.00

Packaging

10-4-28 SL (42)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/29 JH
RJ 10-4-29
(4)

Picklist Print

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Page 1

Work Order ID: 57967



Parent Item: D4038-3



Parent Item Name: Angle. Aft, LH

Start Date: 23/04/2010

Required Date: 30/04/2010

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	14.5000	2.9474			



6061T6 ANGLE 4.00 x 4.00 x .250

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT06

113391

14.5

14.5

mmv=
10/04/21

2.9474 + 2.542

DART AEROSPACE LTD		Work Order: 57967
Description: Angle, Aft, LH		Part Number: D4038-3
Inspection Dwg: 4038	Rev: B	Page 1 of 1

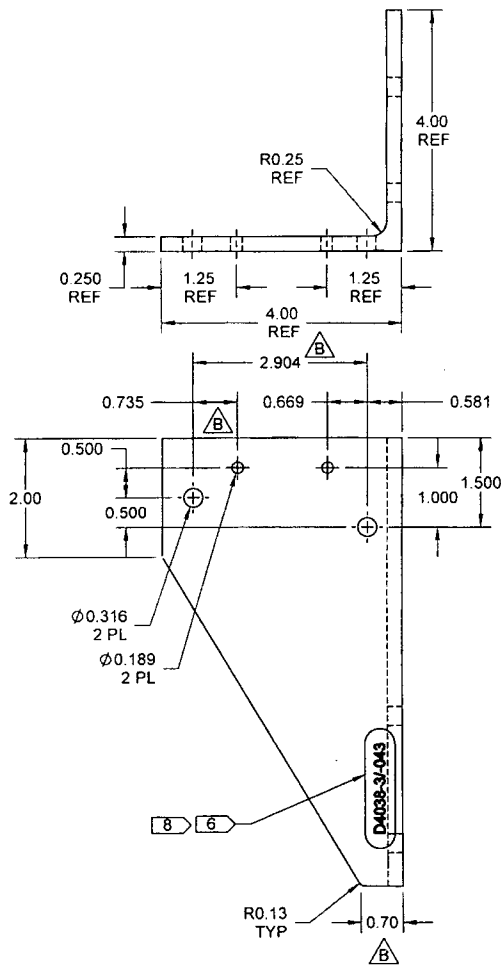
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

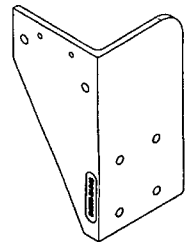
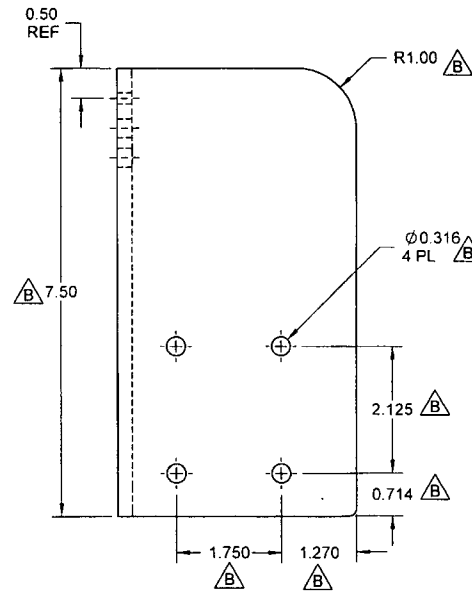
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.50	± .03	7.50	✓			
4.00	± .03	4.00	✓			
1.750	± .010	1.749	✓			
1.270	± .010	1.270	✓			
2.125	± .010	2.122	✓			
.714	± .010	.711	✓			
1.500	± .010	1.498	✓			
1.000	± .010	1.000	✓			
.500	± .010	.500	✓			
2.00	± .03	2.00	✓			
2.904	± .010	2.904	✓			
.669	± .010	.669	✓			
.70	± .03	.70	✓			
.581	± .010	.577	✓			
Ø .316	+ .006 - .001	Ø .317	✓			
Ø .189	+ .005 - .001	Ø .191	✓			

Measured by: <i>mw</i>	Audited by: <i>mw</i>	Prototype Approval:	N/A
Date: 10/04/25	Date: 10/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



w/o 57967



NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.19 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

D4038-3 ANGLE, AFT, LH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4038	SHEET 5 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.01.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-04-14